

Sept 12

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:19:47 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STOP
 Job Number : 28183
 Estimate Number : 10516
 P.O. Number : N/A Part Number : D28054
 This Issue : 15/08/2006 S.O. No. : N/A Drawing Number : D2805 REV. B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : N/A Material : N/A
 Due Date : 08/09/2006 Qty: 20 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: A 01.03.21 New Issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X01500 6061-T6 Bar 1.5" x 1.5"



Comment: Qty.: 0.2756 f(s)/Unit Total : 5.5125 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch:

M16954 X 16
M18147 X 4

J.G 06/08/16

20

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Bar: 3.150" Long +0.010/-0.030"

J.G 06/08/16

20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr

Identify as D2805-5

ml 06/08/19

PTU

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/08/19

5.0 QC8 SECOND CHECK




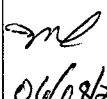

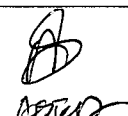

Comment: SECOND CHECK

JL 06/08/20

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: HA Date: 06.08.21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/19	3	1 piece move in the vice.		destroy and replace	 06/08/26	 06.08.21		 06.08.21

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:19:47 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 28183

Part Number: D28054

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-08-22

(20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

SP

06/08/23

(20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST387*

SP

06/08/23

(20)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.24

Job Completion



U 20.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

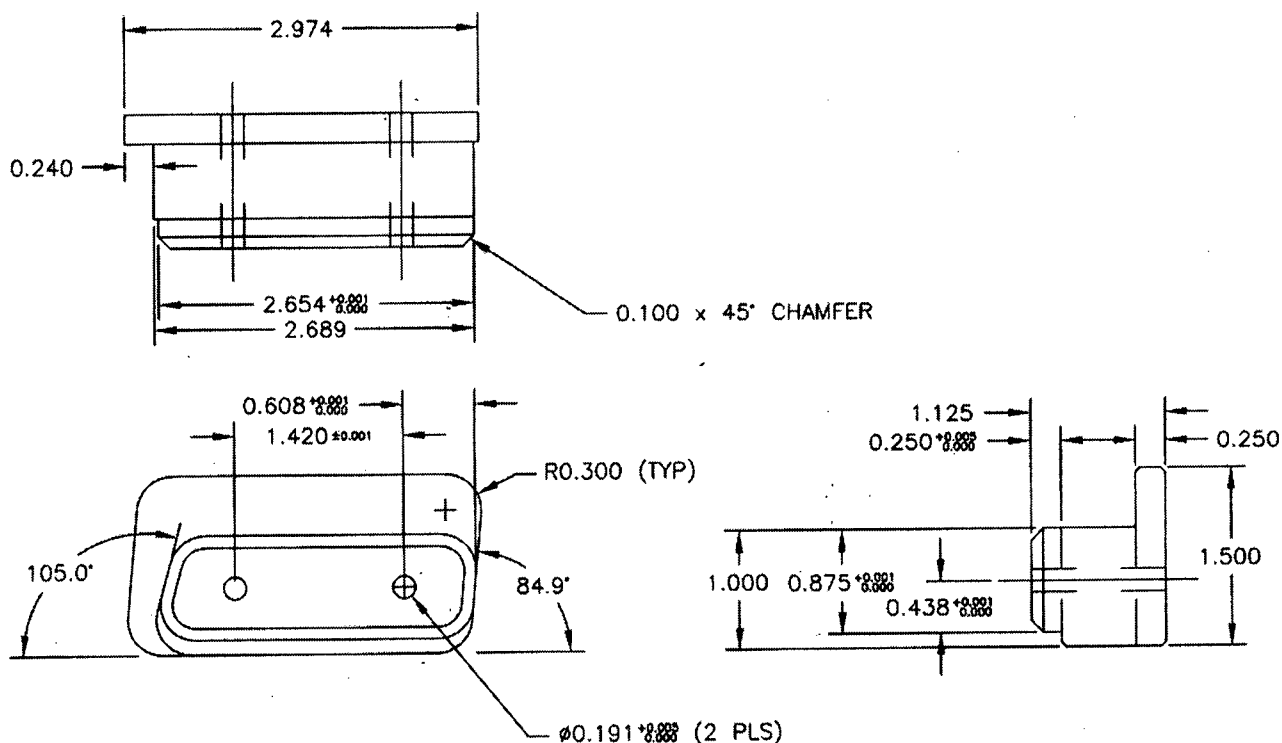
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16



D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

REFERENCE ONLY

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

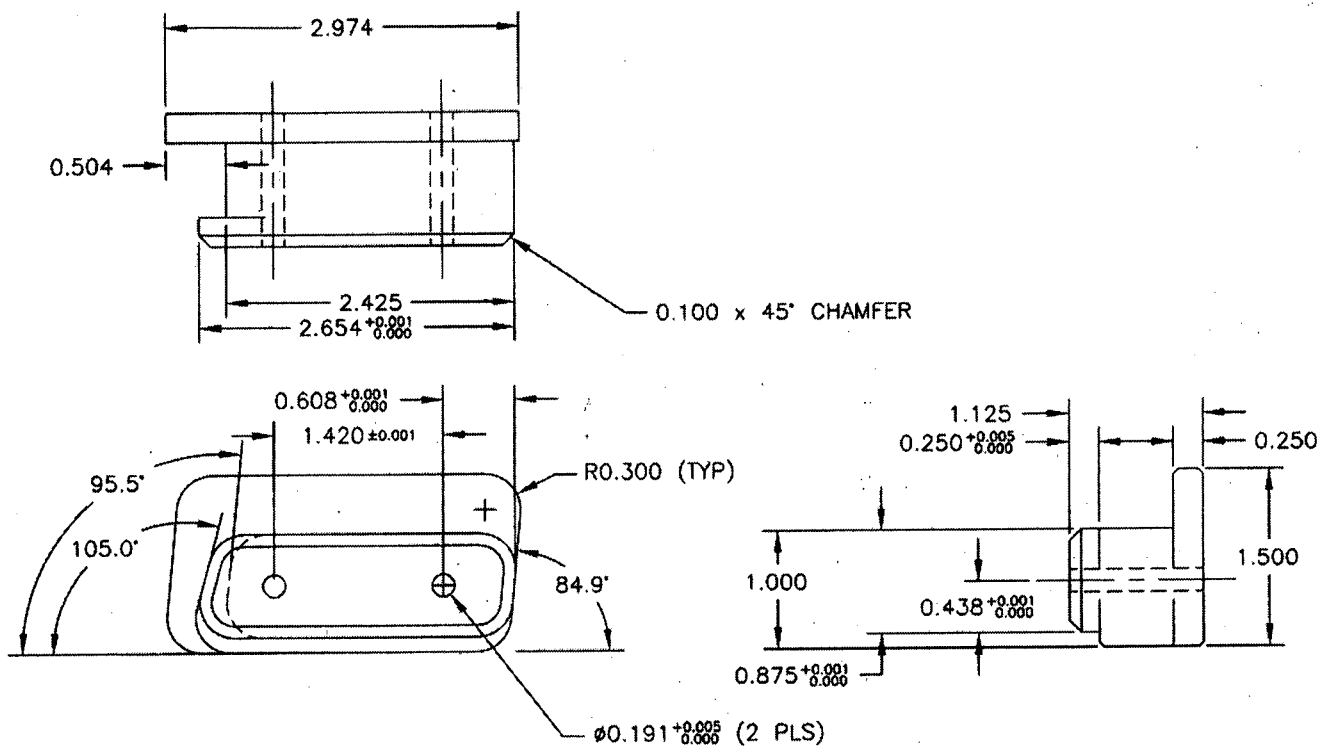
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order:	
Description: Stop		Part Number:	D2805-4
Inspection Dwg: D2805 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010	2.971"	✓			
0.100 x 45°	+/-0.010	0.090" x 45°	✓			
2.425	+/-0.010	2.428"	✓			
2.654	+0.001/-0.000	2.655"	✓			
0.504	+/-0.010	0.504"	✓			
0.608	+0.001/-0.000	0.608"	✓			
R0.300	+/-0.010	R0.300"	✓			
Ø0.191	+0.005/-0.000	Ø0.196"	✓			
1.420	+/-0.001	1.421"	✓			
105.0°	+/- 0.5°	105.0°	✓			
95.5°	+/-0.5°	95.5°	✓			
1.125	+/-0.010	1.130"	✓			
0.250	+0.005/-0.000	0.250"	✓			
0.250	+/-0.010	0.255"	✓			
1.500	+/-0.010	1.496"	✓			
0.875	+0.001/-0.000	0.875"	✓			
0.438	+0.001/-0.000	0.438"	✓			
1.000	+/-0.010	0.999"	✓			

Measured by: J.F.	Audited by: ml	Prototype Approval:	N/A
Date: 06/08/18	Date: 06/08/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.05	New Issue	KJ/JLM	